

NCP-19-7535



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3237-1

Job Sheet 199627



Part No: D3237-1

Job Qty: 500 ft

Part Name: Seal Retainer(\$ Per Ft)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 10/28/19

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B IPP A 04.02.04 New issue KJ/DS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing - Ft	500 ft	10/28/19		0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	500 pcs	10/28/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		

POSITIVE
RECALL

POSITIVE RECALL

EFFECTIVE 19/08/19 AUTH DAS 13 9-89
EASED 55 DATE OCT 24 2019
9-89



Container No: S225668



Part: D3237-1

Job No: 199627

Serial No/Batch: S225668

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/23/19

Plex 8/28/19 2:36 PM Dart.Lavoie.Chantal

				B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	500 pcs	10/28/19	0.00 0.00	QC 6 - 9	OCT 23 2019 DAS 68 9-89
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	500 pcs	10/28/19	0.00 0.00	Packaging 3 - 1 - B4B	DAS 28 9-89
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

Plex 8/28/19 2:36 PM Dart.Lavoie.Chanta

Plex 8/28/19 2:36 PM Dart.Lavoie.Chanta

<i>see manual</i>	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
	Packaging 3 - 27 - B4B				
	Packaging 3 - 28 - B4B				
	Packaging 3 - 29 - B4B				
	Packaging 3 - 30 - B4B				
	Packaging 3 - 31 - B4B				
	Packaging 3 - 32 - B4B				
	Packaging 3 - 33 - B4B				
	Packaging 3 - 34 - B4B				
	Packaging 3 - 35 - B4B				
Packaging 3 - 36 - B4B					
140 QC 21 - SA FT	500 ft	10/28/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 OCT 24 2019
				QC 21 - SA - 53	9-29
Part Op 100 - (Purchasing) Issue P/O: _____ D3237-1 Seal as per Dwg D3237 Possible Supplier: Mill Supply Inc. P/N: R- Descriptions: 1025 (comes in 50 ft rolls) 110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached 120 - (QC6- All purchased or subcontracted products) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D3237-1P	Seal Retainer	500 (1 ea)	100-Purchasing - Ft	5225667	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Purchasing - Ft	D3237-1P	500	0	0	
Part Specifications					
Specifications could not be found.					



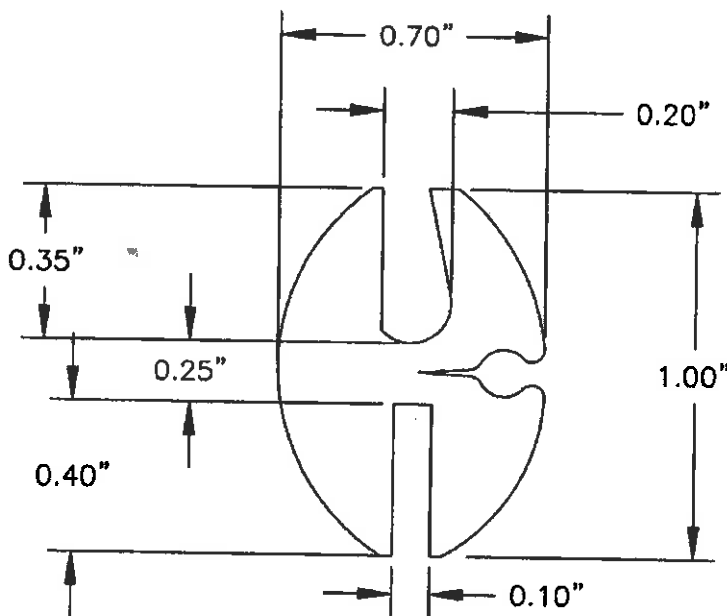
corner



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3237	REV. B SHEET 1 OF 1
DATE 04.05.05		TITLE SEAL		SCALE NTS	
A	04.01.22		NEW ISSUE		
B	04.05.05		REMOVE (REF) & ADD QSI 018		

RELEASED
04.05.12

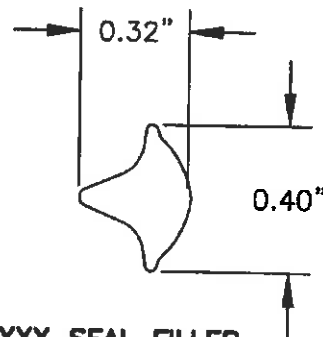
SPECIFICATION CONTROL DRAWING



D3237-1-XXXX SEAL RETAINER

WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES
EG. 98.0" LONG EQUALS D3237-1-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1025
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE
SPECIFIED



D3237-3-XXXX SEAL FILLER

WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES
EG. 98.0" LONG EQUALS D3237-3-0980

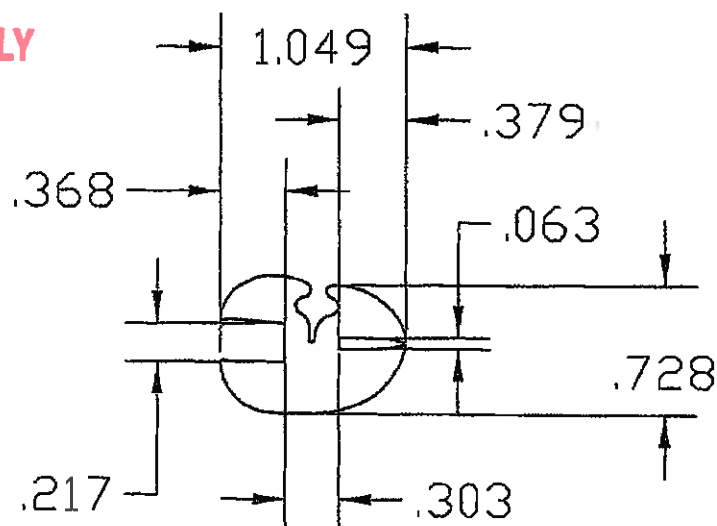
PURCHASE: MILL SUPPLY, INC. P/N R-1029
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE
SPECIFIED

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DATE	REV. NO.	REDAWN
5/21/10	-	-

REFERENCE ONLY



RMA CLASS	3 COMMERCIAL	CUST./PROJECT	VARIOUS	
DRAWING DESIGNATION	E3	MATERIAL	70 +/- 5 EPDM	
DIMENSIONS (IN INCHES)		CUST. NUMBER		
		GRM NUMBER	61683	
		DATE DRAWN	5/21/10	BY: F.D.R.
		APPROVED		DATE:
		NOTES		
ABOVE	UP To			
0	0.06	±0.016		
0.06	0.10	0.020		
0.10	0.16	0.027		
0.16	0.25	0.031		
0.25	0.39	0.039		
0.39	0.63	0.051		
0.63	0.98	0.063		
0.98	1.57	0.079		
1.57	2.48	0.098		
2.48	3.94	0.128		



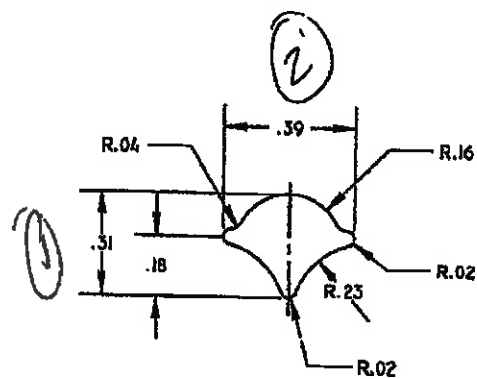
2625 NW INDUSTRIAL
PORTLAND, OR 97210
PHONE: 503 226-6971
FAX: 503 226-6976

DART SUPPLIER DEVIATION REQUEST



A. Supplier Information		B. Part Information	
Date: 10/18/19		Part Number: D3237-1P (GRM# 61683FT)	
Name: Deirdre Bergstrom		Description: window channel 50' coil	
Contact: Deirdreb@griffithrubber.com		Revision: N/A	
Phone #: 503-226-6971		PO Number: POHB044383	
Requestor Title: Project Manager		Quantity of parts affected: 500 ft	
C. Deviation Information			
Deviation Request is: Deviation to ship parts prior to Dart Aero print update			
Product Related	☒	1st Time	☒
Process Related	☐	Repeat	☐
		Permenant	☐
		Temporary	☒
		Duration Until Dart Aero	
Current Requirement	Requested Deviation		Reason for Deviation
1) 0.70" 2) 0.20" 3) 1.00" 4) 0.10" 5) 0.40" 6) 0.25' 7) 0.35" ALL TOLERANCES PER DART QSI 018	1) 0.728" 2) 0.217" 3) 1.049" 4) 0.063" 5) 0.379" 6) 0.303" 7) 0.368" ALL TOLERANCES PER ARPM E3 COMMERCIAL		THESE ARE GRIFFITH STANDARD PARTS, SAMPLES WERE SENT TO DART FOR REVIEW AND ACCEPTED ON 9/10/19 PER CHANTAL LAVOIE

DATE	REV.	NO.	
1/10/12			ORIGINAL RELEASE



RMA CLASS		3 COMMERCIAL	CUST./PROJECT	VARIOUS / LOCK-KEY	
DRAWING DESIGNATION		ES	MATERIAL	80+/-5 DUROMETER EPDM	
DIMENSIONS (IN INCHES)			CUST. NUMBER	VARIOUS	
			GRM NUMBER	16002	
			DATE DRAWN	4/19/12	BY: KPB
			APPROVED		DATE:
			NOTES	SCALE - 2:1 SOLD AS 600' (3X200') BULK ROLL	



2625 NW INDUSTRIAL
PORTLAND, OR 97210
PHONE: 503 226-6971
FAX: 503 226-6976

Sheet 1 of 1

Sheet 1 of 1

[illegible]



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044383**



Supplier: ROY003-VU
Royal Bank Visa (Robert Aboud)
x
xx
ON
Canada

PO No: POHB044383
PO Date: 8/29/19
Due Date: 10/29/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

ONE TIME ONLY

APPROVAL

BY: [Signature]

AUG 27, 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Credit Card

Freight Terms:

Special Comments: GRIFFITH RUBBER MILL

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199627	D3237-1P	GRM 61683FT	Seal Retainer	Firmed	-	10/29/19	500 ft	0 ft	500 ft	\$1.21/ft	\$605.00
2	199629	D3237-3P	GRM16002	Seal Filler	Firmed	-	10/29/19	600 ft	0 ft	600 ft	\$0.22/ft	\$132.00
Grand Total:												\$737.00

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/29/19 1:10 PM Dart.Lavoie.Chantal



GRIFFITH RUBBER MILLS:GXT
507 N LEE ST.
GARRETT IN 46738
260-357-0876 Fax: 260-357-3997

PACKING SLIP

85628-GXT

10/22/2019

Ship To:
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Bill To:
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

Date Shipped	Ship Via	F.O.B.	Drop Ship PO#	Terms	
10/22/2019	FEDERAL EXPRESS	ORIGIN:PREPAID		CREDIT CARD	
Shipped	Your Item Number / Description		GRM PN	PO Number	Lot Number
500 FT	D3237-1P WINDOW CHANNEL 50' COIL		61683FT	POHB044383	2647755
600 FT	D3237-3P LOCK KEY3-CAVITY TACKED (EACH TACKED LENGTH 200')		16002	POHB044383	2450687
1 EACH	INSPECTION-REPORT-GXT PPAP/FIRST ARTICAL INSPECTION REPORT		INSPECTION-REI	POHB044383	
1 EACH	SURCHARGE-GXT 4% SURCHARGE :: GXT		SURCHARGE-GX	POHB044383	

RECEIVED
OCT 23 2019
DART AEROSPACE LTD.

RECEIVED
OCT 23 2019
DART AEROSPACE LTD.

Thank you!



CERTIFICATE OF COMPLIANCE/ORIGIN

DATE: 10/22/2019

GRIFFITH RUBBER MILLS:GXT
507 N LEE ST.
GARRETT IN 46738
p 260-357-0876

Pack Slip No: 85628-GXT
Customer: DART AEROSPACE LTD.
Customer PO: POHB044383

UNITED STATES OF AMERICA

Part No. D3237-1P Rev GRM PN: 61683FT	Description WINDOW CHANNEL 50' COIL	DAS 68 9-89
Total Shipped 500	FG Lot Number 2647755	

PRIMARY MATERIALS

Item Number	Description	Lot Number
7825C	EPDM-ST 70 +/-5	
7825C	EPDM-ST 70 +/-5	4914432

SUBSTITUTES

Item Number	Description	Lot Number
61683FT	WINDOW CHANNEL 50' COIL	2647755

RECEIVED

OCT 23 2019

DART AEROSPACE LTD.

We Certify that all materials and processes used in the production of the finished part above conform to the requirements of the listed purchase order and/or applicable drawings and specifications.

Matthew S. Martel
Corporate Quality Manager
800.312.9677

Sheet 1 of 1

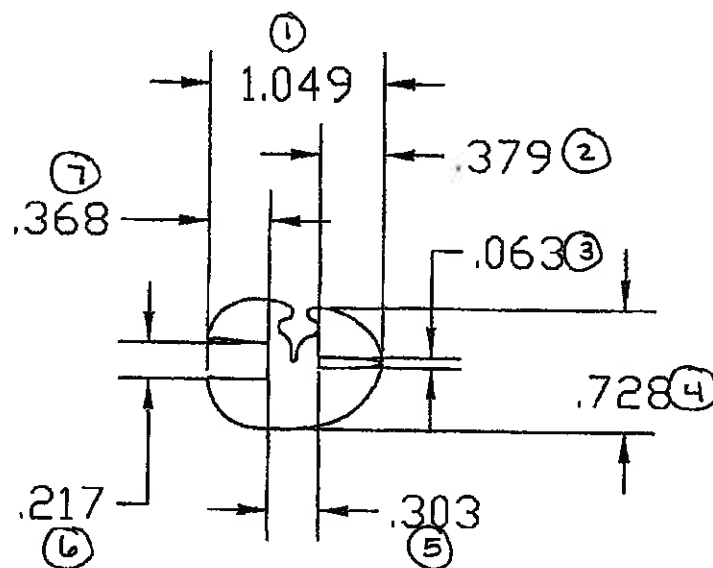
Form 2: Product Accountability – Raw Material, Specifications and Special Process(es), Functional Testing

[illegible]

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

[illegible]

DATE	REV.	NO.
5/21/10	-	REGRASS



RMA CLASS		3 COMMERCIAL	CUST./PROJECT	VARIOUS	
DRAWING DESIGNATION		E3	MATERIAL	8 70 +/- 5 EPDM	
DIMENSIONS (IN INCHES)			CUST. NUMBER		
			GRM NUMBER	61683	
			DATE DRAWN	5/21/10	BY: F.D.R.
			APPROVED	DATE:	
			NOTES		



2625 NW INDUSTRIAL
PORTLAND, OR 97210
PHONE: 503 226-6971
FAX: 503 226-6976

DART SUPPLIER DEVIATION REQUEST



A. Supplier Information		B. Part Information	
Date: 10/18/19		Part Number: D3237-1P (GRM# 61683FT)	
Name: Deirdre Bergstrom		Description: window channel 50' coil	
Contact: Deirdreb@griffithrubber.com		Revision: N/A	
Phone #: 503-226-6971		PO Number: POHB044383	
Requestor Title: Project Manager		Quantity of parts affected: 500 ft	
C. Deviation Information			
Deviation Request is: Deviation to ship parts prior to Dart Aero print update			
Product Related	☒	1st Time	☒
Process Related	☐	Repeat	☐
		Permenant	☐
		Temporary	☒
		Duration Until Dart Aero	
Current Requirement	Requested Deviation		Reason for Deviation
1) 0.70" 2) 0.20" 3) 1.00" 4) 0.10" 5) 0.40" 6) 0.25' 7) 0.35" ALL TOLERANCES PER DART QSI 018	1) 0.728" 2) 0.217" 3) 1.049" 4) 0.063" 5) 0.379" 6) 0.303" 7) 0.368" ALL TOLERANCES PER ARPM E3 COMMERCIAL		THESE ARE GRIFFITH STANDARD PARTS, SAMPLES WERE SENT TO DART FOR REVIEW AND ACCEPTED ON 9/10/19 PER CHANTAL LAVOIE

DART SUPPLIER DEVIATION REQUEST



D. Corrective Action Taken		E. Preventive Action	
SAMPLES SENT TO DART AERO FOR REVIEW AND APPROVED, DART DRAWING WILL BE UPDATED AFTER RECEIPT OF PO# POHB044383		N/A	

F. DART Approvals	Signature	Date	Approve / Disapprove
Purchasing	<i>Charles Yarnes</i>	12/10/21	Approved
Engineering	<i>[Signature]</i>	12/10/21	Approved
Manufacturing	<i>[Signature]</i>	12/10/21	Approved
Quality	<i>[Signature]</i>	12/10/21	Approved
Other			

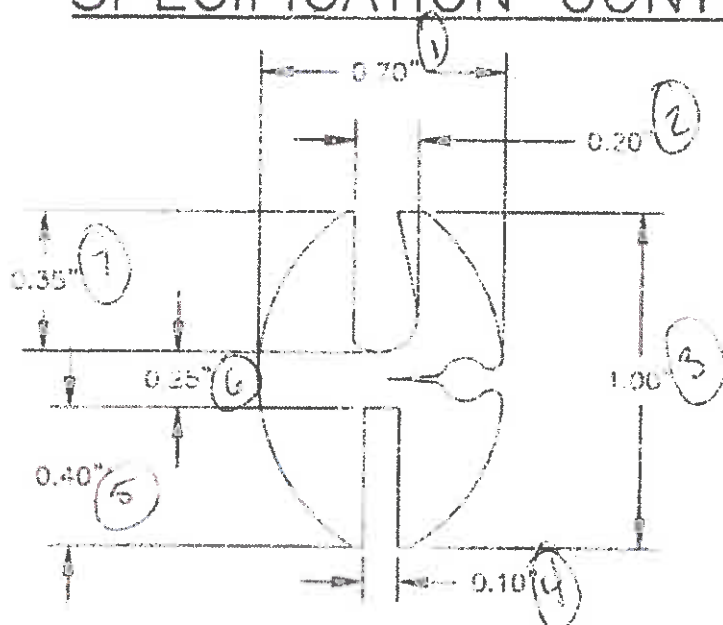
G. Disposition (Completed by DART)			
Drawing Change Required?	Yes ☒	No ☐	If Yes ECN / URF Number: <i>CAR 19-334</i>
Supplier Corrective Action Request Required?	Yes ☐	No ☒	If Yes SCAR Number:

Comments



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3237	REV B SHEET 1 OF 1
DATE 04.05.05		TITLE SEAL	SCALE NTS
A	04.01.22	NEW ISSUE	
B	04.05.05	REMOVE (REF) & ADD QSI 018	

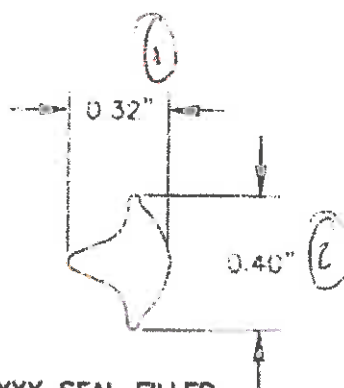
SPECIFICATION CONTROL DRAWING



D3237-1-XXXX SEAL RETAINER

WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES
EG. 98.0" LONG EQUALS D3237-1-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1025
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE
SPECIFIED



D3237-3-XXXX SEAL FILLER

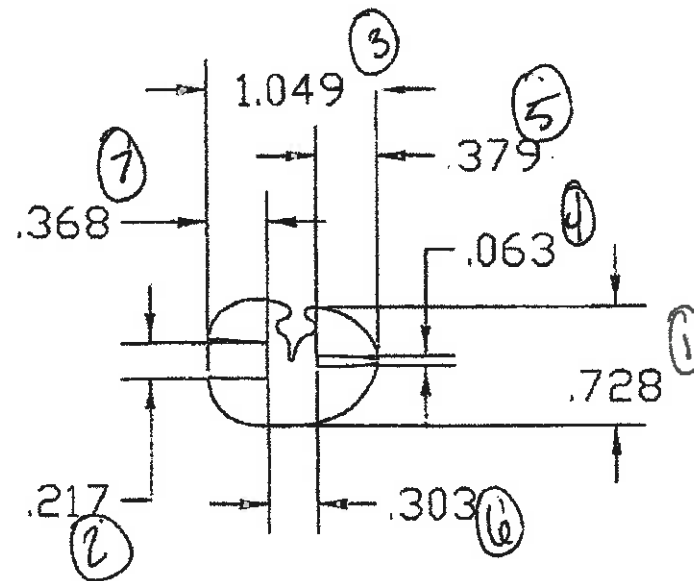
WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES
EG. 98.0" LONG EQUALS D3237-3-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1029
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE
SPECIFIED

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DATE	REV.	NO.
5/21/10	-	-
		REDRAWN



RMA CLASS		3 COMMERCIAL	CUST./PROJECT	VARIOUS	
DRAWING DESIGNATION		E3	MATERIAL	70 +/- 5 EPDM	
DIMENSIONS (IN INCHES)			CUST. NUMBER		
			GRM NUMBER	61683	
			DATE DRAWN	5/21/10	BY: F.D.R.
			APPROVED	DATE:	
			NOTES		

ABOVE	UP TO
0	0.08
0.08	0.10
0.10	0.16
0.16	0.25
0.25	0.39
0.39	0.63
0.63	0.98
0.98	1.57
1.57	2.48
2.48	3.94

±0.015
0.020
0.027
0.031
0.039
0.051
0.063
0.079
0.088
0.128



2625 NW INDUSTRIAL
PORTLAND, OR 97210
PHONE: 503 226-6971
FAX: 503 226-6976

Entered: 7/2 Date: 07/24/19



NCR No. 19-7535

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: <u>199627</u>		DISPOSITION		DEPARTMENT/PROCESS							
Part No. <u>D3237-1</u>		Rework ☐ Scrap ☐ Use-as-is ☒		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐	
Date: <u>12/10/23</u>		Sequence #:		QTY Affected: <u>500 ft</u>				MRB (QSI042) <u>INSP 12</u> <u>9/12/23</u>			
Description Work Order Deviation				Disposition				Completed By <u>9/12/23</u>			
Distributor was no longer able to supply per dwg. Original Manufacturer Manufacturer was not Found (Griffith Rubber Mills). Griffith supplied p/n 61683 61683 FT. Engineering will update dwg D3237 to match Griffith dims & tolerance.				Acceptable based on comparison to historically purchased seal.				Lead hand / Supervisor DAS 55 9-89 OCT 23 2019			
Root Cause				FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
				Other/Details:							